

Claims

1. A mold for manufacturing holders such as crates, comprising at least two mold parts, moveable relative to each other in a first direction of movement, in which at least one mold cavity is included, the mold cavity being provided on at least one side with a wall part moveable in a second direction of movement which is moveable between a first, retracted position and a second position moved forward, while the mold cavity, with said wall part in the second position, is in a desired product forming position and, with said wall part in the first position, has a volume greater than with said wall part in the second position, while the first and the second direction of movement mutually include an angle.
2. A mold according to claim 1, wherein the first and the second direction of movement include an angle of between 20 and 90 °, in particular an angle between 45 and 90°, and preferably between 60 and 90°.
3. A mold according to claim 2, wherein the first direction of movement is approximately at right angles to the second direction of movement.
4. A mold according to any one of claims 1 – 3, wherein at least two moveable wall parts are provided in, at least of, the at least one mold cavity.
5. A mold according to claim 4, wherein each moveable wall part has a second direction of movement, preferably approximately at right angles to the first direction of movement.
6. A mold according to claim 3 or 4, wherein a core part of the mold cavity is provided, wherein on at least three and preferably on four sides of said core part a moveable wall part is provided.
7. A mold according to any one of the preceding claims, wherein in the mold a central core part is provided, while on at least one side a second core part is provided, at a distance from said central core part and wherein the or a moveable wall part is located at the side of said second core part facing away

from the central core part, and the second direction of movement of the respective wall part is directed towards the second core part and/or the central core part, while the mold cavity is designed such that during use plastic can move from a space between the central core part and the second core part along the second core part between the second core part and the respective wall part and can be pushed by the respective wall part against the second core part.

8. A mold according to any one of the preceding claims, wherein the at least one mold cavity is designed for forming a holder with a bottom surface and a longitudinal wall extending away from the bottom surface, the bottom surface and/or the longitudinal wall having a thickness which is small relative to the height of the longitudinal wall, measured at right angles to the bottom surface, while the height of the longitudinal wall is relatively great relative to the dimensions of the bottom surface, more in particular at least one quarter of a diagonal or central line of said bottom surface.

9. A mold according to claim 8, wherein the or at least one longitudinal wall forming part of the mold is arranged for forming a cavity in said longitudinal wall, at least part thereof, while a moveable wall part is designed for forming at least one wall of said cavity.

10. A mold according to any one of the preceding claims, wherein the mold cavity comprises a wall part moveable in the first direction in the mold cavity, in particular near or in a bottom surface forming part, while at least one injection opening is provided in or near said bottom surface forming part.

11. A mold according to any one of the preceding claims, wherein for the or each moveable wall part drive means are provided.

12. An assembly of a mold according to any one of the preceding claims and a pressing device, wherein the first direction of movement is substantially parallel to the pressing direction of the pressing device.

13. An assembly according to claim 12, wherein the or each moveable wall part, in particular drive means therefor, are moveable independently of the pressing device.

14. A method for manufacturing a holder with a bottom surface and a longitudinal wall reaching upwards from the bottom surface, wherein a mold, in particular according to any one of claims 1 – 11, in a first direction of movement is closed and in a mold cavity thereof, plastic is introduced while at least one moveable wall part of the mold cavity has been or is brought into a retracted position, such that the distance between said moveable wall part and an opposite wall part is relatively great, whereupon said at least one moveable wall part is moved forward, in the direction of said opposite wall part, such that said distance is reduced and plastic included therebetween is pressed together and/or at least partly compressed, while the first direction of movement includes an angle with the closing direction of the mold.

15. A method according to claim 14, wherein the mold is closed before the or each moveable wall part is moved in said first direction of movement towards the opposite wall part.

16. A method according to claim 14, wherein the or a said moveable wall part is moved in the direction of said opposite wall part while the plastic is introduced into the mold cavity.

17. A method according to claim 14, wherein the or a said moveable wall part is moved in the direction of said opposite wall part after at least 80% of the required plastic has been introduced into the mold cavity.

18. A method according to claim 17, wherein the or each moveable wall part is moved at a speed such that in the plastic at least adjacent the respective moveable wall part adiabatic heat development occurs.

19. A method according to any one of claims 14 – 18, wherein a holder with at least partly hollow walls is formed.